

Work Order ID 74126

Friday, September 23, 2011 7:42:56 AM



PRELIMINARY ISSUE

Page 1

Item ID: D3806-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 9/23/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/27/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3806

Rev X

B

16.10.04
ECN 11-640

0.00

100



Waterjet

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3806

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

Manual M.11

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

11/09/23

5

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID - 74126

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Page 2

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Item Name: Bar

Start Date: 9/23/2011 Start Qty: 5.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC8- Inspect parts -second check	0.00	SK	11-09-23					
QC Quality Control	Memo	0.00							
150 	Identify as per dwg & Stock Location: <u>u/h</u>	0.00							
Packaging Packaging	Memo	0.00							
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/9/23 (52)

11/10/14

POSITIVE RECALL
EFFECTIVE 11-09-23 AUTH u mf
RELEASED u DATE 11-10-14
SW 11-640 11-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, September 23, 2011 7:42:54 AM

Page 1

Work Order ID: 74126

Parent Item: D3806-5

Parent Item Name: Bar



Start Date: 9/23/2011

Required Date: 9/27/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.500X2.500		Purchased	No			100	f	13.0870	0.93	4.894737			
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304 BAR .500 x 2.50

Location

Loc Qty

Loc Code

MAT050

13.087

112764

8.312

116135

0.375

117685

4.4

1117176

19.1 f 11/09/23

304 .250 X .500

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NOTE: Date & initial all entries

w/o rivets

PRELIMINARY ISSUE

11.09.16

PB1	REVISED D3806-1/3 TO EASE MANUFACTURABILITY AND CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PAR11-106	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE USA, INC. KENT, WA	
DRAWN		DRAWING NO.	REV. PB1
CHECKED		D3806	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		BAR	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	11.09.16		

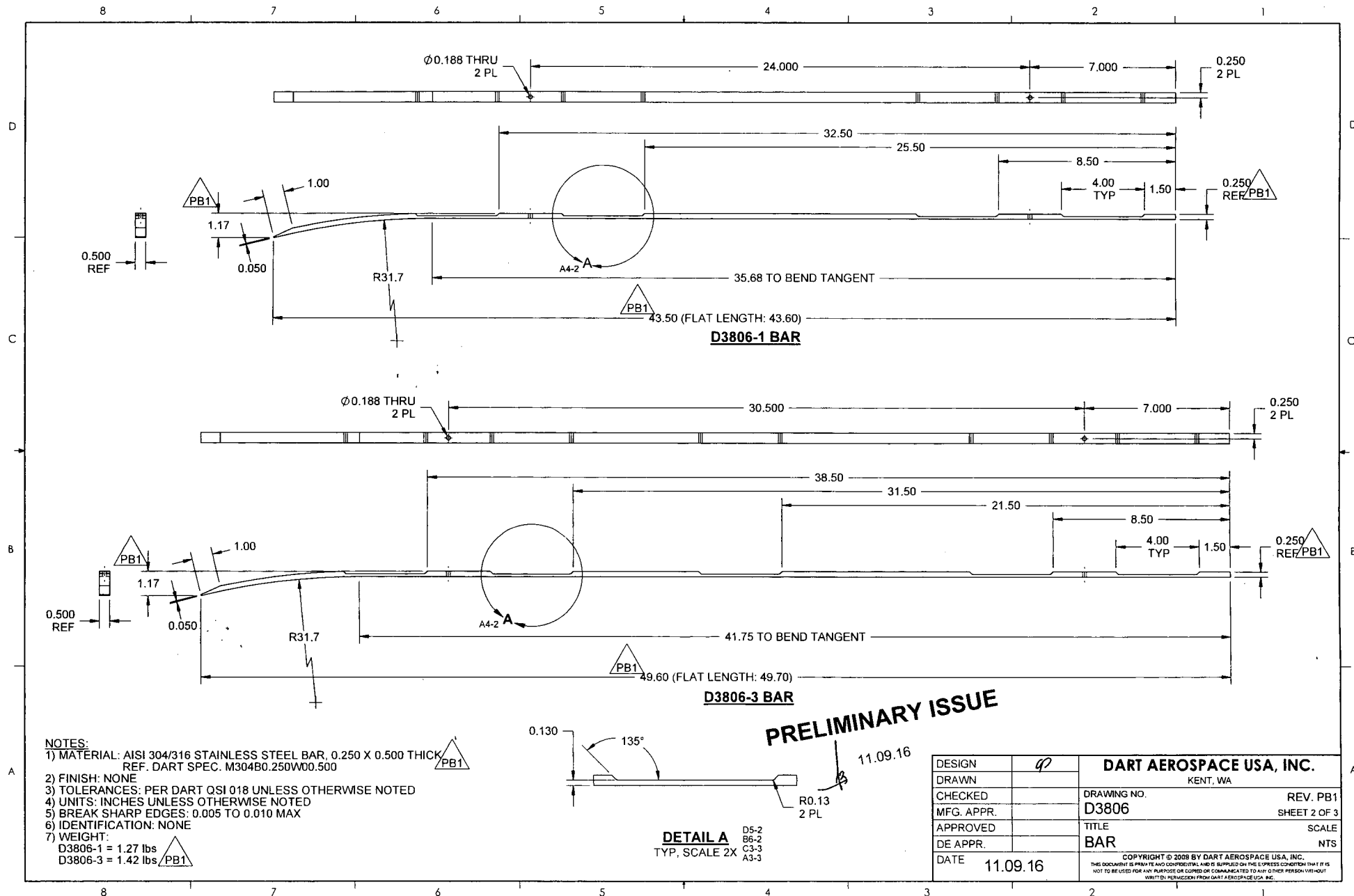
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

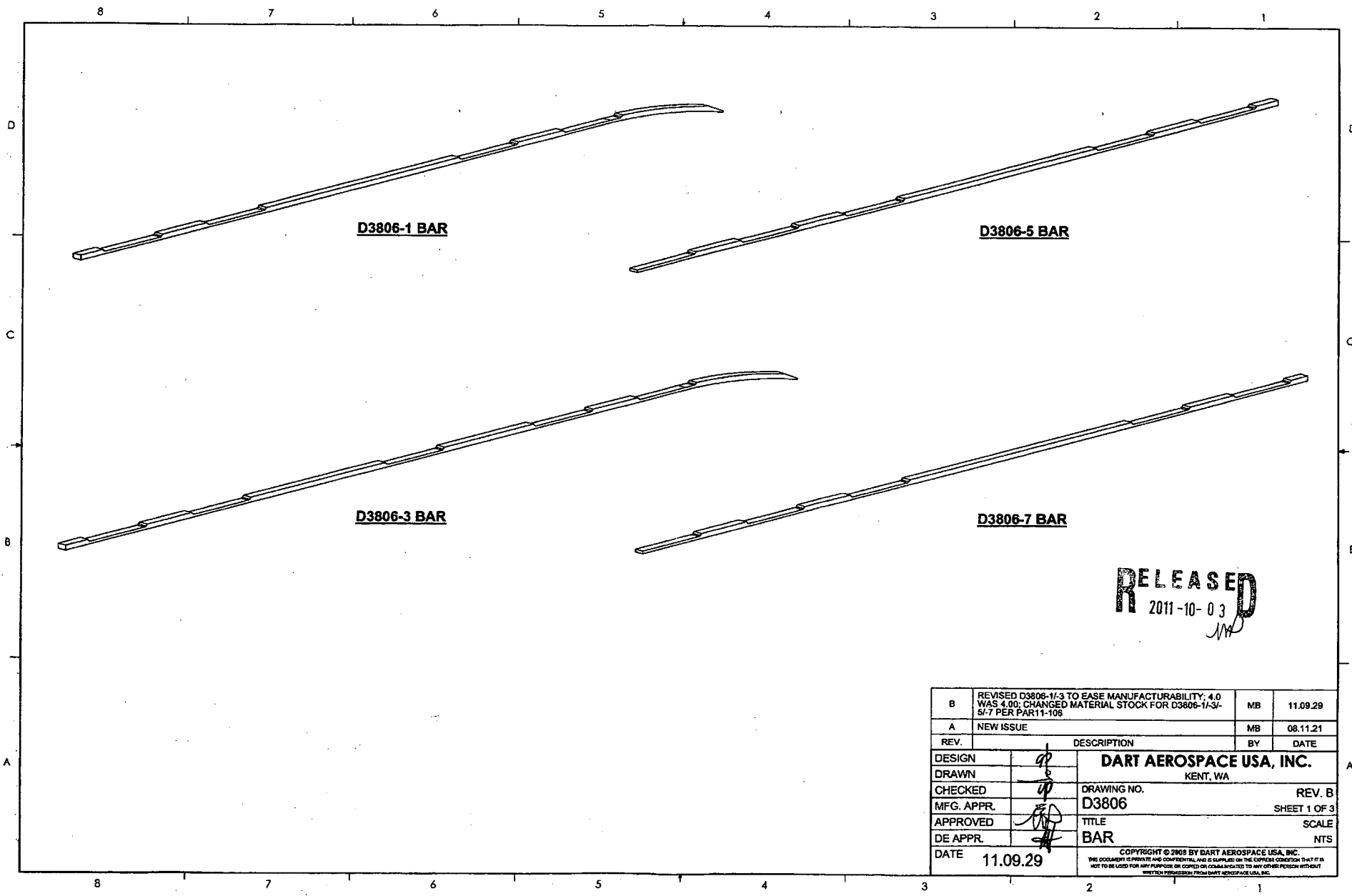
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

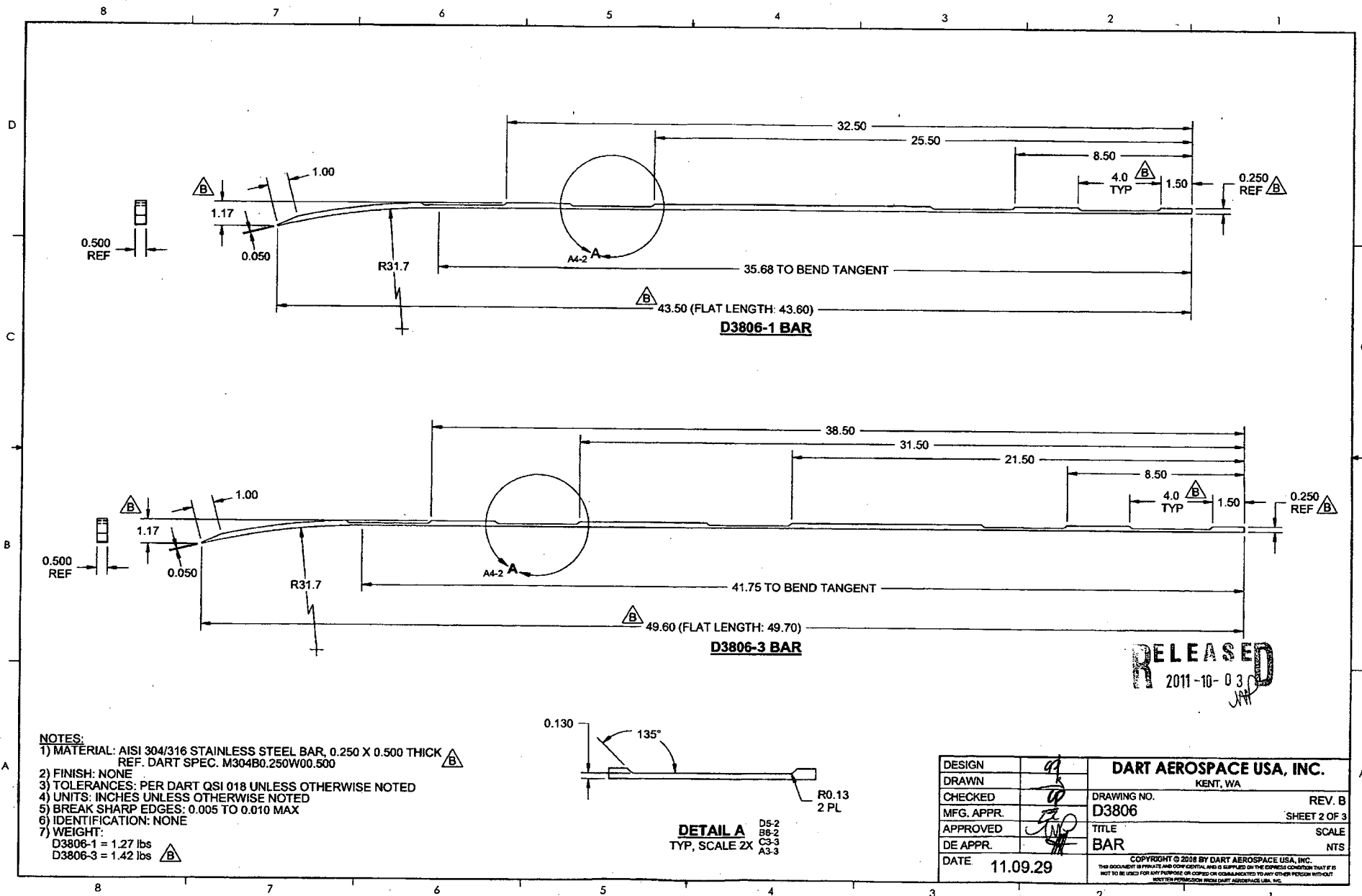
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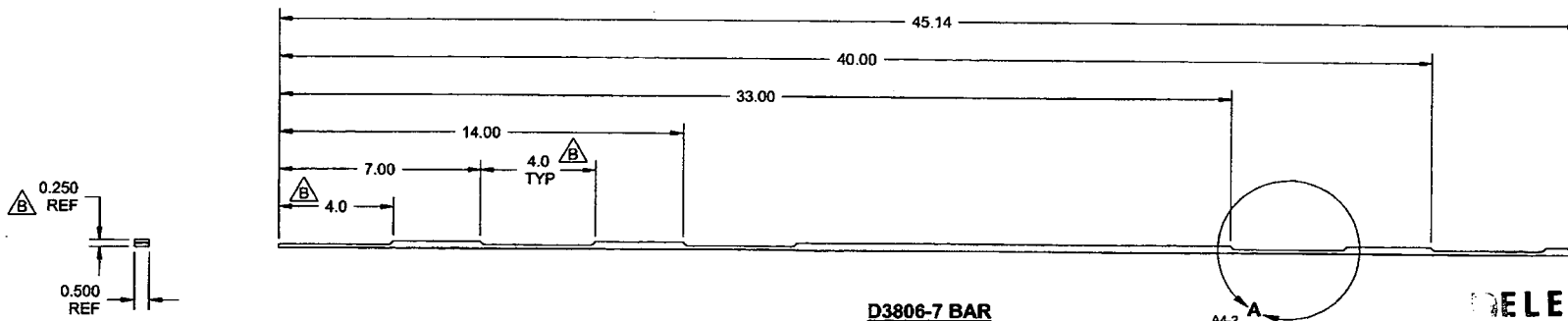
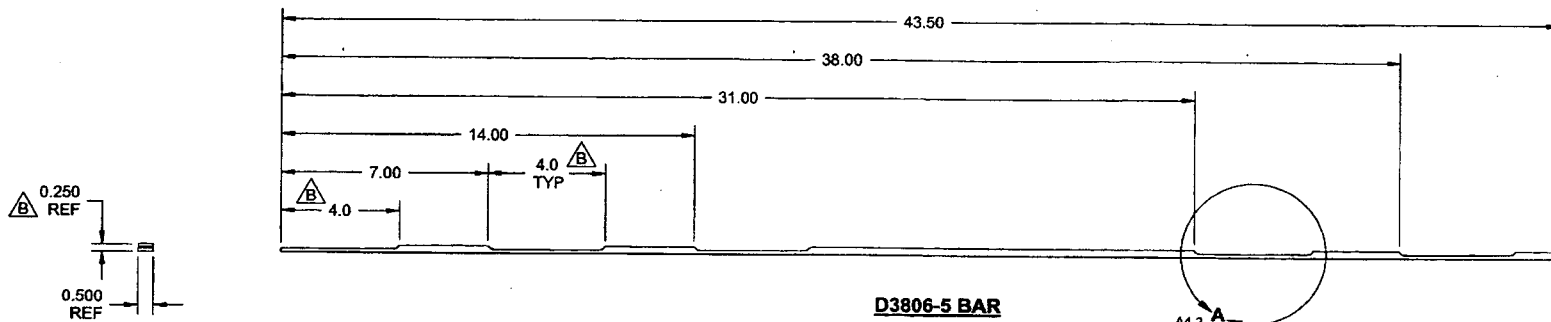
RELEASED
2011-10-03

B	REVISED D3806-1/3 TO EASE MANUFACTURABILITY: 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PAR11-106		MB	11.09.29
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC.			
DRAWN	KENT, WA			
CHECKED	DRAWING NO. D3806		REV. B	
MFG. APPR.	TITLE BAR		SHEET 1 OF 3	
APPROVED	DATE 11.09.29		SCALE NTS	
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RELEASED
2011-10-03
JH

8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.
DRAWN		KENT, WA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3806 SHEET 3 OF 3
APPROVED		TITLE SCALE
DE APPR.		BAR NTS
DATE	11.09.29	

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8 7 6 5 4 3 2 1